

Work Order ID 67193

Thursday, March-10, 2011 8:47:30 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 3/10/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: 11-03-10 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100 0.00



DOCUMENT CONTROL

DC

Memo

SN 924

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

11 04 11 (5)

110 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod M114703

M115928

3-Grind End Plate flush

11-04-01 5 \$

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

x5 0 3E11/04/01

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloyon

x5 4xL

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x5 11/AE 11/04/02.

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11.04.04 5 0

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod M1147C3

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.04.08 5 0

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/05

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/05

Quality Control

XJ
44

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

5 BL 11-4-5

Hand Finishing

Dart Aerospace Ltd

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M 116964

5

BR 11-8-6

Powdercoat

Memo

0.00

Powder Coating

START TIME: *10:20*
OVEN TEMPERATURE: *320°*
FINISH TIME: *10:50*

230

Wing Walk as per dwg QSI005 4.4 Batch *M 11731*

0.00



5 HA of M 1104/07

HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00



M 11 01 07 (5)

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/12 SP SD

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

M 11 04 11 (5)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: _____

LevB

11/4/12 SP SD

Dart Aerospace Ltd

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Stop



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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12 [Signature]
11-04-12
(5)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, March 10, 2011 8:47:36 AM

Page 1

Work Order ID: 67193

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH




Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1  Step		Manufactured	No			110	Each	20.0000	1	5			
<div> <div>Location</div> <div>WA <u>367196</u></div> <div>66623</div> <div>66624</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3067-1  End Plate		Manufactured	No			110	Each	128.0000	1	5			
<div> <div>Location</div> <div>WA</div> <div><u>65969</u></div> </div> <div> <div>Loc Qty</div> <div>128</div> <div>128</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3219-1  Plate		Manufactured	No			110	Each	116.0000	2	10			
<div> <div>Location</div> <div>WA</div> <div><u>66133</u></div> </div> <div> <div>Loc Qty</div> <div>116</div> <div>116</div> </div> <div> <div>Loc Code</div> <div></div> </div>													

Handwritten: 11.03.15

Handwritten: 11.04.01

Handwritten: 11.04.01

Handwritten: 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, March 10, 2011 8:47:36 AM

Page 2

Work Order ID: 67193

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each

113.0000

2

10



Spacer



11.04.04

Location

Loc Qty

Loc Code

WA

113

65072

6

66131

107

MS20600-AD4W4

Purchased

No

180

Each

2,263.000

16

80



Rivets



11.04.04

Location

Loc Qty

Loc Code

ST321

2263

113368

38

114181

11

114718

2

115573

70

115640

31

116022

4

116188

1500

116712

607

D3065-041

Manufactured

No

180

Each

57.0000

1

5



Step Leg Assembly Hi



11.04.04

Location

Loc Qty

Loc Code

WA

57

63554

17

66149

40

Thursday, March 10, 2011 8:47:37 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

180 Each

128.0000

1

5



End Plate



11.04.04

Location

Loc Qty

Loc Code

WA

128

65969

128

Purchased No

250 Each

118.0000

2

10

AN3-35A



Bolt



11/4/11

Location

Loc Qty

Loc Code

ST353

118

116191

78

117094

40

Manufactured No

250 Each

47.0000

2

10

D3235-1



Mounting Lug



B66941

Location

Loc Qty

Loc Code

ST471

47

65073

47

Manufactured No

250 Each

35.0000

1

5

D3278-041



Support Assembly



11/4/11

Location

Loc Qty

Loc Code

ST471

35

66155

35

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

30.0000

16

80

Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

20

Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A Purchased

No

250

Each

137.0000

2

10

Bolt

Location

Loc Qty

Loc Code

ST341

137

114292

1

116191

1

116549

35

116704

100

Thursday, March 10, 2011 8:47:37 AM

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Page 4

Dart Aerospace Ltd

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

D2618 Manufactured No 250 Each 63.0000



Bushing



2

10

66942

11/4/11

Location

Loc Qty

Loc Code

ST019

63

65071

3

66132

60

D2230-3 Manufactured No 250 Each 12.0000



Lug



4

20

B66936

B67763

11/4/11

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

8

55452

2

66126

6

D2856-400 Manufactured No 250 f 146.2980



Abraison Strip



1.2

6

11/4/11

52

Location

Loc Qty

Loc Code

ST403

146.2980421

56626

0.00004211

59920

43.381

63735

102.917

*** cut (2) at 7.20" (D2856-400-720) ***

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Shop Packet Print

Page 5

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

250

Each

2,376.000

2



Nut

Location

Loc Qty

Loc Code

ST300

2376

116391

776

116540

800

116549

800

11/4/11

10

AN4-13A

Purchased

No

250

Each

592.0000

8



Bolt

Location

Loc Qty

Loc Code

ST357

592

116786

292

117094

300

11/4/11

40

MS21042L5

Purchased

No

250

Each

970.0000

2



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

944

115594

248

116105

496

116548

200

11/4/11

10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

250

Each

4,376.000

8



Nut



40
11/4/11

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000

40

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

24.0000

4



Washer



20
11/6/11

3X
11/4/11

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07 06 04 *H*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67193*
PS 11-03-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

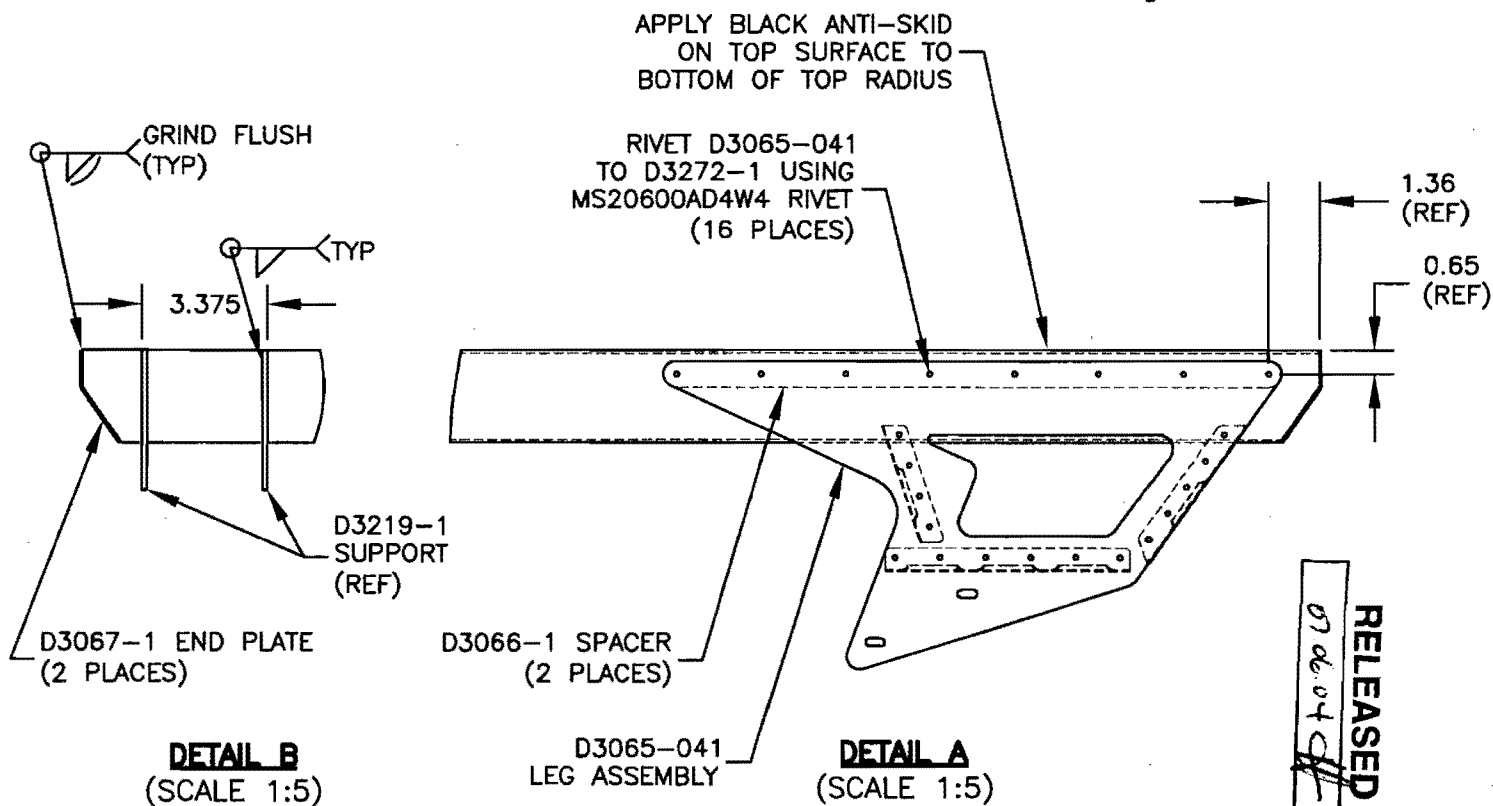
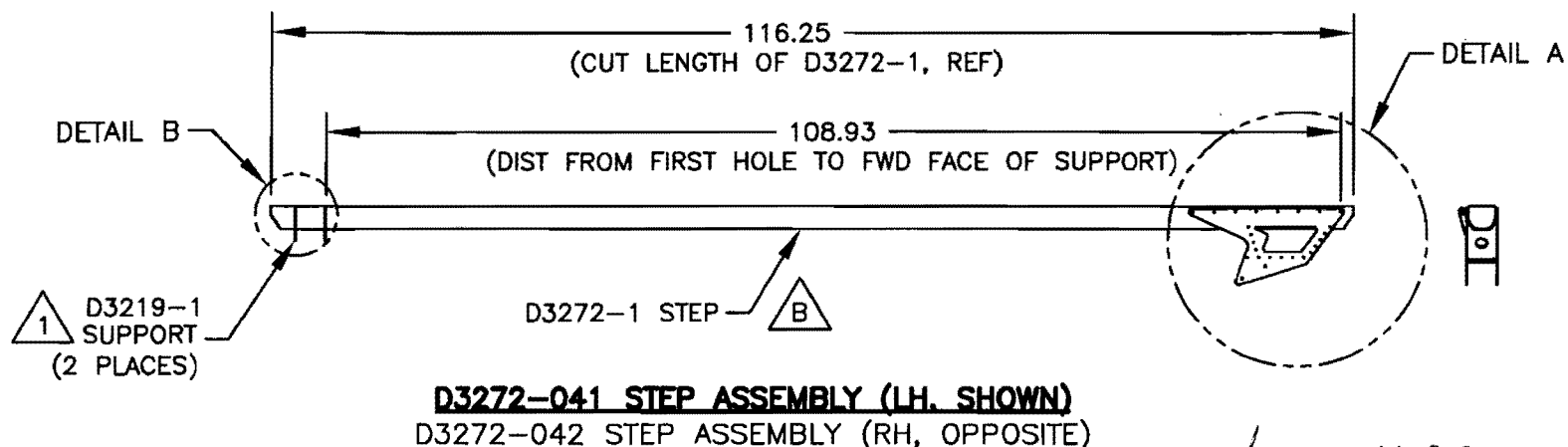
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	q	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
				SHEET 2 OF 3
				SCALE 1:20



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

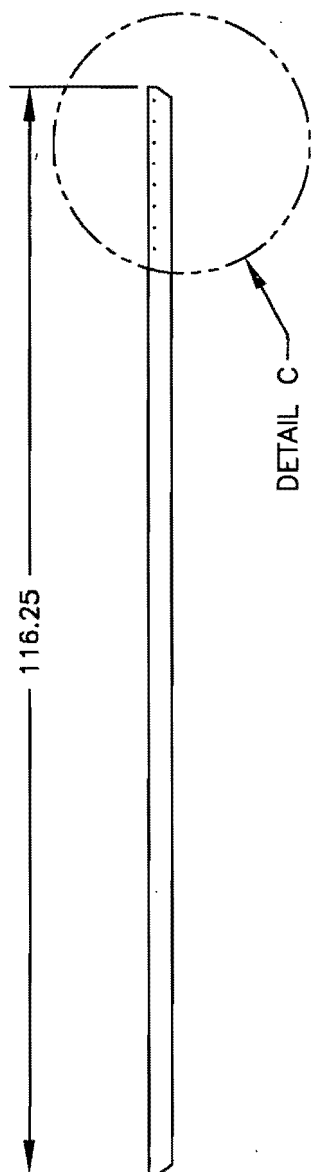
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

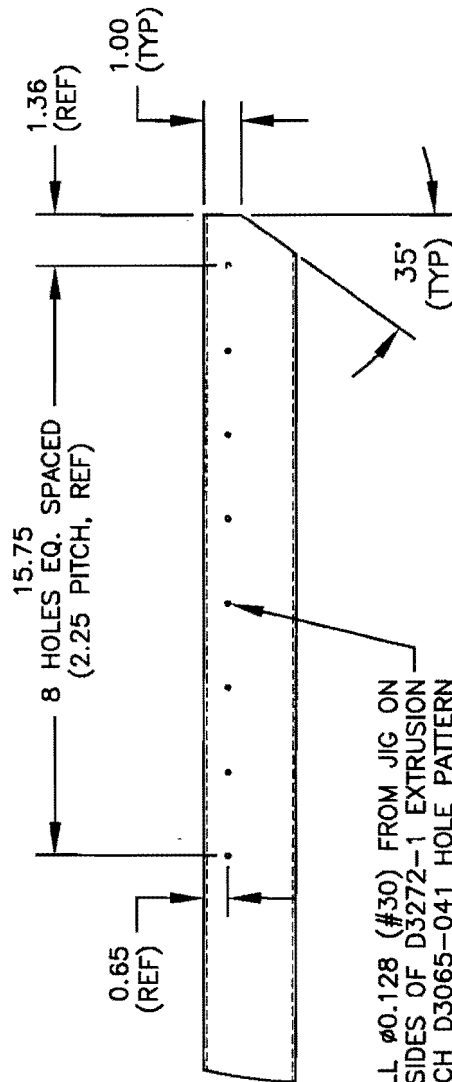


DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

w/047193



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	18	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

